

Date: Wednesday, 1/3/2007 1:27:44 PM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DRAIN TUBE ASSEMBLY
Job Number : 30129	
Estimate Number : 12623	
P.O. Number : N/A	Part Number : D2127251915
This Issue : 1/3/2007 S.O. No. : N/A	Drawing Number : D212-725-1 UNDER RW
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : U/R
Previous Run : N/A	Material : N/A
Written By : <u>JLM 01-03</u>	Due Date : 1/10/2007 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : Est Rev:A New Issue 07-01-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T0750W035	6061T6 tubing
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Comment: Qty.: 3.3000 f(s)/Unit Total : 3.3000 f(s)
 6061T6 tubing with .035" wall
 Batch: M103098

SB 07/01/04 ①

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Form tube as per Dwg D212-725-1 & DT8909 Template

SB 07/01/04 ①

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

JLM 07-01-04

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

A.M 07/01/04 ①

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

N/A

6.0	AN81812D	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Nut
 Batch: 103111

U SB 07-01-05

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DRAIN TUBE ASSEMBLY

Job Number: 30129

Part Number: D2127251915

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

MS2081912J

Sleeve



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Sleeve

Batch: 11251

N/A

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install sleeves & nut then flare tube as per Dwg D212-725-1.

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

N/A

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

LL 07-01-05 OK to w/o

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

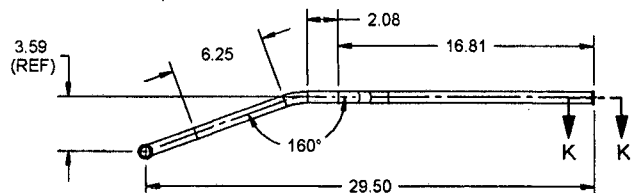
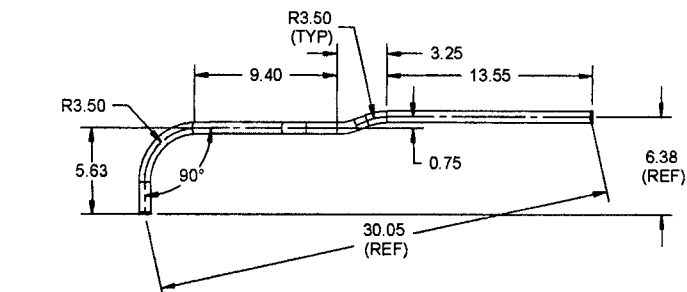
N/A

032 A

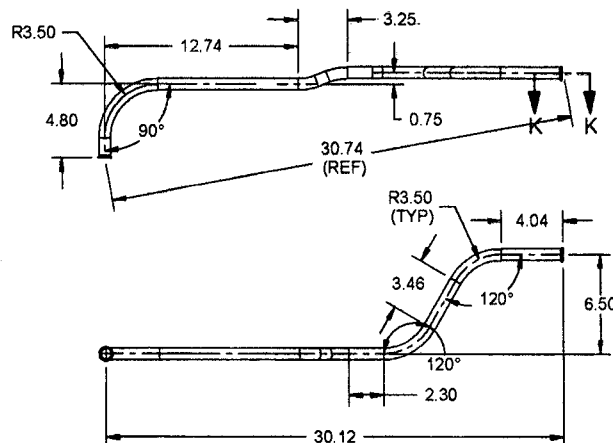
Job Completion



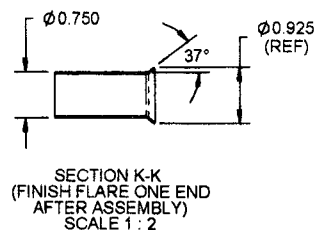
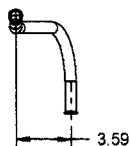
u 07-06-05



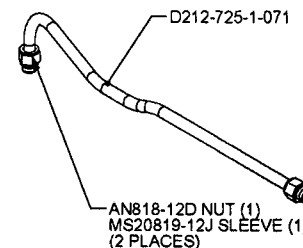
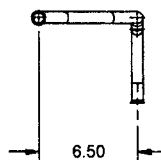
D212-725-1-071 DRAIN TUBING
MANUFACTURE PER TEMPLATE DT8908



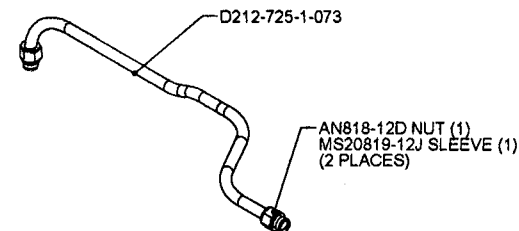
D212-725-1-073 DRAIN TUBING
MANUFACTURE PER TEMPLATE DT 8909



SECTION K-K
(FINISH FLARE ONE END
AFTER ASSEMBLY)
SCALE 1:2



D212-725-1-913 DRAIN TUBE ASSY



D212-725-1-915 DRAIN TUBE ASSY

D212-725-1-071-073:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING Ø0.750 x 0.035 WALL (REF. DART SPEC. M6061T6T0.750W0.035)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

PRELIMINARY ISSUE

DESIGN DC	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DS	APPROVED	DRAWING NO. D212-725-1	REV. A SHEET 28 OF 37
DATE 06.12.08		TITLE 212S DETAIL PARTS	SCALE 1:8
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